Work Order Thursday, July 07	r <b>ID 71677</b> 7, 2011 12:12:161	PM									Page 1
Revision ID: Item Name:		rt <b>Qty:</b> 8.00			Cust Item I			s s	etup Star Sto	1 18811181 8	
	Process Plan:	CZ_	Date:(O)(C			ate:		F	Run Star Sto <sub>l</sub>		
Sequence ID/ Work Center ID		ration cription		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3208	Revision 1	Nbr									,
Waterjet FLOW CNC Waterjet	ı	W WATER JET  Memo 1-Cut as p Deburr if		0.00 0.00 Rev:_ <b>A \</b> □Prog Rev:_	<u> </u>			B11-	8 <u>-3</u>		
QC Quality Control	QC2-	- Inspect parts off Memo	machine FAI/FAIB	0.00			·e.	B11-	8-3	· 	
120 QC	QC8-	- Inspect parts - s  Memo	econd check	0.00 E W	ا م ا م ا			(+12	)		

Quality Control

	•								
W/O:			wo	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						8			
						<u> </u>			
					·				
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	<b>A:</b>	Date:	
		esolution:							
NCR:	,		WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	OTED	Description of NC	Corrective Action Section B			Verific	cation	Approval Chief Eng	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng					QC Inspector
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. <sup>7</sup> 1 	·								
					i.				
	·								

#### Work Order ID 71677

Thursday, July 07, 2011 12:12:16 PM



Page 2

Item ID:

D3208-3

Accept



Setup Start



**Revision ID:** 

Item Name:

Pedal Mount Angle

**Start Date:** 

Required Date: 7/21/2011

7/7/2011

Start Qty: 8.00 Req'd Qty: 8.00



Date:

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run

Start Stop

Stop



Sequence ID/

**Work Center ID** 

130

Brake NC

Brake NC

Operation

**Description** 

Set Up/

**Run Hours** 0.00

Tool ID

Tool # Plan Code

Accept **Qty** 

Reject Qty

Reject Number Stamp

Insp.

NC BRAKE

0.00

Deburr D3208-3 ☐ Form D3208-3 as per Dwg D3208 ☐ Polish any marks on part

within 01. of Dwg D3208

Sp 11/03/08

140

Quality Control

QC5- Inspect part completeness to step on W/O

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Hand Finishing

Memo

Memo

0.00

W/O:			W	ORK ORDER CHANG	iES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									!
<del></del>									
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	1
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	CTED	Description of NC	Corrective Action Section B			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Initial Action Description Chief Eng Chief Eng		Sign & Section C		Chief Eng	QC Inspector
								}	
į									

#### Work Order ID 71677

Thursday, July 07, 2011 12:12:16 PM



Page 3

Item ID:

D3208-3

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Pedal Mount Angle

**Start Date:** 

7/7/2011

Start Qty: 8.00

Req'd Qty: 8.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Required Date: 7/21/2011

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Reject

Reject

Insp.

Sequence ID/ **Work Center ID** 

160



Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Qty

Number Stamp

170

**Packaging** Packaging

Memo

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location: 202

0.00

Memo

0.00

CK 11/08/09.

W/O:	· [		WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date:	·/
	Res	olution:	Disposition	:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description  Chief Eng	on B Sign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector
				Only 211g	Julio				
	1 1		1						1

## **Picklist Print**

Thursday, July 07, 2011 12:12:14 PM

Work Order ID: 71677

Parent Item:

D3208-3

Parent Item Name: Pedal Mount Angle



Start Date: 7/7/2011

Required Date: 7/21/2011

Page 1

Start Qty: 8.00

177285

Required Qty: 8.00

Comments:

IPP: B□04.05.25□Material changed for Step 4□KJ/JLM□ IPP Rev:C Now on Waterjet 06-10-12 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	212.9456	0.0659	0.554947	( )		
										BI	1-8-3	3	

6061-T6 .063 Sheet

<u>Locati</u>	<u>on</u>	Loc Qty	Loc Code
MAT0	21	212.9455684	
	116308	28.4755684	
	117285	184.47	

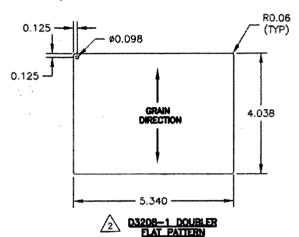
W/O:			WORK ORDER CHANGES										
DATE	STEP	PR	OCEDURE CHAN	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
					¥ ¥								
Part No	:	PAR #:	Fault Categ	ory:	NC	R: Yes i	No DQ	<b>A</b> :	_ Date: _				
	Re	esolution:	Disposition		QA	: N/C Clo	sed:		Date: _				
NCR:			WORK ORDE	R NON-CONFO	RMANCE	(NCR)							
DATE	STEP	Description of NC Section A	Initial	Section B Sign &		Verification Section C			Approval				
		Section A	Chief Eng	Action Descript Chief Eng		Date	Secti	on C	Chief Eng	QC inspector			
							,						
						1							

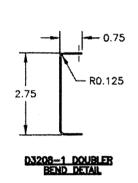


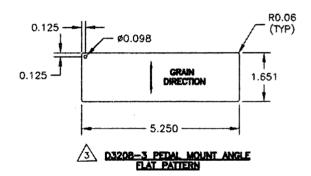


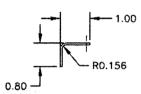
DESIGN	DRAWN BY	1	OSPACE LTD ONTARIO, CANADA
CHECKED,	APPROVED	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE		TITLE	SCALE
04.01.27		DOUBLER	1:3
		*	

A	04.01.27 NEW ISSUE
AL	+ 7 04.05.25 CHONGE DIM; NOTE 3) CHANGE









D3208-3 PEDAL MOUNT ANGLE BEND DETAIL OF COPY

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 7/677

7 £ 1

CZ11107/07

NOTES:

1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)

- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S:063)
  4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S:080)
  5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

3) MATERIAL: 6061-TE (00-A-250/11) 0.068" THICK (M6061T65.063)

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DART AEROSPACE LTD	Work Order:	7/677
Description: Pedal Mount Angle	Part Number:	D3208-3
Inspection Dwg: D3208 Rev: A1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

		X First Artic	cle	Prototype				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
Ø0.098	+0.005/-0.001	, 102	<b>&gt;</b>		V BOZ			
1.651	+/-0.010	1.654	Je .		V			
5.250	+/-0.010	5.253	×		V			
0.125	+/-0.010	1,654	7		V			
			_	-				
					•			
			1					
			_					
		-						

Measured by: B	Audited by:	Prototype Approval:	N/A
Date: ((- %-7)	Date: WOS/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.10.27	New Issue	KJ/JLM A	
	·		<del></del>	7~7